

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014958**Date Inspected:** 18-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 8CW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045246 performing Shielded Metal Arc Welding process for weld 046 located on PCMK SEG047B. ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1. Critical weld repair report identified as B-CWR-1631.

OBG SEGMENT 8AE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220063 performing Flux cored Arc Welding process for weld 019 located on PCMK OBE8. ZPMC QC Mr. Li Jia monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-T-2134.

OBG SEGMENT 8BW

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 049769 performing Shielded Metal Arc Welding process for weld 012 located on PCMK SEG045A. ZPMC QC Mr. Liu Hua Jia monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1. Critical weld repair report identified as B-CWR1628.

OBG SEGMENT 8AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045246 performing Shielded Metal Arc Welding process for weld 044 located on PCMK SEG043*. ZPMC QC Mr. Li Jia monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1. Critical weld repair report identified as B-CWR1613.

OBG SEGMENT 8AW-8BW

This QA Inspector observed ABF QA Inspector performing magnetic particle inspection on deck panel splice weld between OBG segment 8AW and 8BW

OBG SEGMENT 8CE

This QA Inspector observed ZPMC personnel performing carbon air arc gouging for the weld between side panel and bottom panel (E3) at PP70.

OBG SEGMENT 8CW

This QA Inspector observed ZPMC QA Inspector performing Ultrasonic inspection for the weld between longitudinal diaphragms to floor beam (W3) at PP71.

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 7DE

ZPMC NWIT No: 006007

Punch List Item No: 681

This Q.A Inspector performed Ultrasonic testing of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (U.T) report for this date. The members are identified as the OBG segment 7DE.

Weld Designations are as follows.

FB028-006, 126

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

Only general conversation was held between QA and QC

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
